

Work Order ID 135436

Wednesday, August 12, 2015 4:28:26 PM

135436

Page 1

Item ID: D2484 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Locknut
 Start Date: 8/12/15 Start Qty: ~~10.00~~ **50** ***10*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: ~~10.00~~ ***10*** Customer:
 Reference:

Approvals: Process Plan: WLS Date: AUG 14 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2484	Rev A								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 29497 Order per Dwg D2484 Material release note required
mc master P/N: 91343A100

CL AUG 18 2015 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

50x 80/508-21

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00
 Quality Control

50

DAS
 38
 9-89
AUG 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Work Order ID 135436***135436***

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Wednesday, August 12, 2015 4:28:26 PM

Item ID: D2484

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Locknut

Start Date: 8/12/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/12/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St 057

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

AUG 24 2015

AUG 24 2015

AUG 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Picklist Print

Wednesday, August 12, 2015 4:28:26 PM

Page 1

Work Order ID: 135436

135436

Parent Item: D2484

D2484

Parent Item Name: Locknut

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A00.03.02New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2484P		Purchased	No			110	Each	0.0000	1	10			
D2484P									**				
Lock Nut													

501 8015-08-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

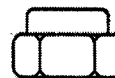


DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED 	DRAWING NO. D2484	REV. A SHEET 1 OF 1
DATE 95:10:06		TITLE LOCK NUT SCALE	

SPECIFICATION CONTROL DRAWING



1/4-20 LOW PROFILE
NYLON LOCK NUT



OR

1/4-20 SERATED FLANGE
LOCK NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 135736 M05
1508-14



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29497**

Purchase Order Date 8/18/2015

PO Print Date 8/18/2015

Page Number 1 of 4

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 330 995 5500

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	D2484P	Lock Nut	8/21/2015		50.00	\$0.38	\$19.15
			Yes		Each		
			8/21/2015				
AS PER DWG D2484 REV. A							
B135436							
MCMASTER P/N: 91343A100							

SP15-08-21

Line Total: \$19.15

2	97787A661	Expandable Pin	8/21/2015		6.00	\$114.68	\$688.08
			Yes		Each		
			8/21/2015				
	AS PER DWG D4711 REV. C B135717						

Line Total: \$688.08

Note:

8/18/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Eric.L

Purchase Order
PO29497

Order Placed By
Chantal Lavoie

McMaster-Carr Number
7489206-02

Page 1 of 1

08/18/2015

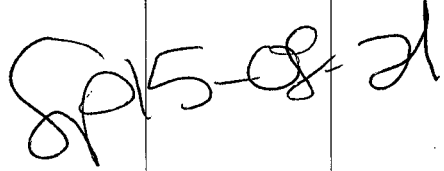
Line	Product	Ordered	Shipped
1	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10	5 Packs	5
2	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length	6 Each	6
3	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size	10 Each	10
4	30365T35 Cast Type 316 Stainless Steel Eye and Clevis Swivel, 5/8" Diameter, 4675# Work Load Limit	10 Each	9
5	90261A154 Helical Insert Installation Tool, 10-24 Internal Thread	1 Each	1
6	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8
7	54875A33 1/4" Square Drive Hex Bit Socket, 5/32" Extra Short, 1-1/16" Overall Length, Chrome	6 Each	6
8	91259A534 Alloy Steel Shoulder Screw, 1/4" Diameter X 5/16" Long Shoulder, 10-24 Thread	50 Each	50

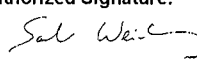
Shipped separately from our Chicago warehouse on 08/18

4	30365T35 Cast Type 316 Stainless Steel Eye and Clevis Swivel, 5/8" Diameter, 4675# Work Load Limit	10 Each	1
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SP15-08-21

McMaster-Carr Supply Company 200 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-Mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 36990004 Purchase Order: PO29497 Release: McMaster-Carr Number: 7489206-02		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 18-Aug-2015 Shipper's Export Declaration (SED): NO EEI 30.36		FOB: ORIGIN	
Intermediate Consignee:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Tax Number:	
Forwarding Agent:		Billing Attention: Shipping Eric.L Attention: Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10 Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	5 PK	\$3.83	\$19.15
2	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Country of Origin: United States Schedule B #: 731829 ECCN #: 9A991 NLR	6 EA	\$114.68	\$688.08
3	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size Country of Origin: United States Schedule B #: 848190 ECCN #: 2B999 NLR	10 EA	\$5.64	\$56.40
4	30365T35 Cast Type 316 Stainless Steel Eye and Clevis Swivel, 5/8" Diameter, 4675# Work Load Limit Country of Origin: Peoples Republic of China Schedule B #: 732690 ECCN #: EAR99 NLR	9 EA	\$69.79	\$628.11
5	90261A154 Helical Insert Installation Tool, 10-24 Internal Thread Country of Origin: United States Schedule B #: 820510 ECCN #: EAR99 NLR	1 EA	\$86.14	\$86.14
Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department. These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.				

Shipping Weight (in kgs): 12		Number of Packages: 1		Invoice Amounts:	
Package Dimensions: 47 X 21 X 17 CM = .017 CUBIC M				Merchandise Amount: \$1,705.08 Canadian GST/HST: \$224.10 Shipping Charges: \$18.80 Total (In USD): \$1,947.98	
				Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: 		Date: 18-Aug-2015		Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA (by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg		Title: Operations Mgr.		Page 1 of 2	